Work Order ID 64514

Tuesday, December 07, 2010 10:00:31 AM

Item ID: D2221
Revision ID:
Item Name: 350 Basket Base
Start Date: 12/7/2010 **Start Qty:** 1.00
Required Date: 12/17/2010 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** M **Date:** 10-27 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D2221	Rev H

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Large Fab	0.00							
Large Fab									
Large Fab	**Memo**	0.00							

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 111585

PLEASE NOTE
IF MAKING -041A OR -043A :
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

pl 11.01.21

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	**Memo**	0.00				1	0		

BE 11.01.24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 64514

Tuesday, December 07, 2010 10:00:31 AM

Item ID: D2221 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: 350 Basket Base

Start Date: 12/7/2010 **Start Qty:** 1.00 **Cust Item ID:**

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00 Sublzy							
QC	**Memo**	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00 JM 4/01/2011				1	4		
HandFinish	**Memo**	0.00							
Hand Finishing									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M115951. **Memo** 1- Plug holes prior to 1ST COAT: START TIME: 3:35 OVEN TEMPERATURE: 400° FINISH TIME: 4:05 ********** 2nd coat if necessary********** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				1		11-01-24.	
140 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				+1			

11/01/25

Dart Aerospace Ltd

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging Packaging	Identify as per dwg & Stock Location: _____	0.00							
	used on w/o 64513 ~~D2607~~				dh 11/01/27	1	0		
	Memo D310-662-045	0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00					11/01/26		

CL 11/01/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, December 07, 2010 10:00:35 AM

Work Order ID: 64514

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 12/7/2010 **Required Date:** 12/17/2010

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:J 05.09.02 Added D3442-1 □KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1		Manufactured	No			100	Each	11.0000	1	1			
Rib													

Location	Loc Qty	Loc Code
WA	11	
63628	11	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-5		Manufactured	No			100	Each	10.0000	2	2			
Rib													

Location	Loc Qty	Loc Code
WA	10	
62996	2	
64269	8	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-7		Manufactured	No			100	Each	5.0000	1	1			
Rib													

Location	Loc Qty	Loc Code
WA	5	
62997	1	
63956	4	

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Work Order ID: 64514

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 12/7/2010 **Required Date:** 12/17/2010

Start Qty: 1.00 **Required Qty:** 1.00

D2232-3 Basket Hinge	Manufactured	No	100	Each	8.0000	2	2 lpl 10.01.21

Location	Loc Qty	Loc Code
WA	8	
63878	2	
64270	6	

B64578 → (2)

D2235-1 Basket Rib	Manufactured	No	100	Each	16.0000	2	2 lpl 11.01.21

Location	Loc Qty	Loc Code
WA	16	
64109	6	
64250	10	

B64636 → (2)

D2581 Mounting Bracket	Manufactured	No	100	Each	15.0000	2	2 lpl 11.01.21

Location	Loc Qty	Loc Code
WA	15	
61953	15	

B64425 → (2)

D3442-1 Shim	Manufactured	No	100	Each	10.0000	2	2 lpl 11.01.21

Location	Loc Qty	Loc Code
WA	10	
63002	10	

(2)

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Work Order ID: 64514

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 12/7/2010 **Required Date:** 12/17/2010

Start Qty: 1.00 **Required Qty:** 1.00

D3825-041 Rib Assembly (Basket End)	Manufactured	No		100	Each	2.0000	2	

Location	Loc Qty	Loc Code
WA	2	
63425	2	

D3826-041 Rib / Gusset Assembly	Manufactured	No		100	Each	2.0000	2	

Location	Loc Qty	Loc Code
WA	2	
63119	2	

D3827-041 Rib Assembly (Inboard)	Manufactured	No		100	Each	0.0000	1	
D3832-1 Mesh (Base)	Manufactured	No		100	Each	3.0000	1	

Location	Loc Qty	Loc Code
WA	3	
63981	3	

D3833-1 Mesh (Base End Face)	Manufactured	No		100	Each	6.0000	2	

Location	Loc Qty	Loc Code
WA	6	
63255	6	

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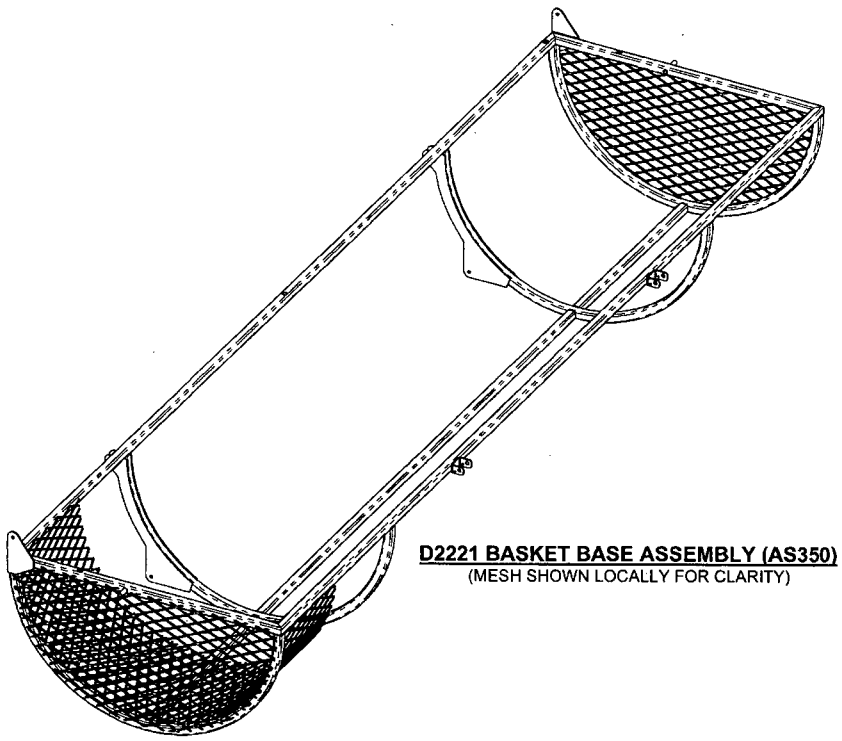
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	**BASKET BASE ASSEMBLY (AS350)**
2	1	D2221-1	RIB
	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

REVISED 08/11/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44514

10-12-7

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: 42.00 lbs APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING

REV.	DESCRIPTION	BY	DATE
H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3625-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21

DESIGN	BW	**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2221 — REV. H
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE: BASKET BASE ASSEMBLY (350) — SCALE: NTS
DE APPR.		
DATE	08.09.18	

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W/O:		WORK ORDER CHANGES					
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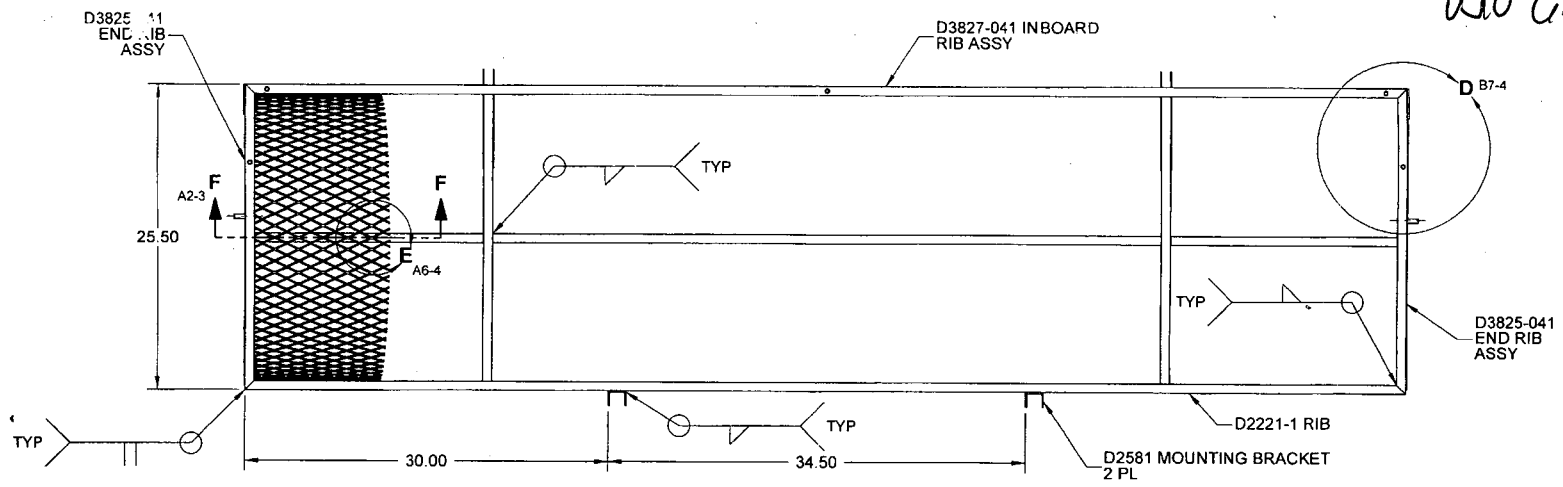
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

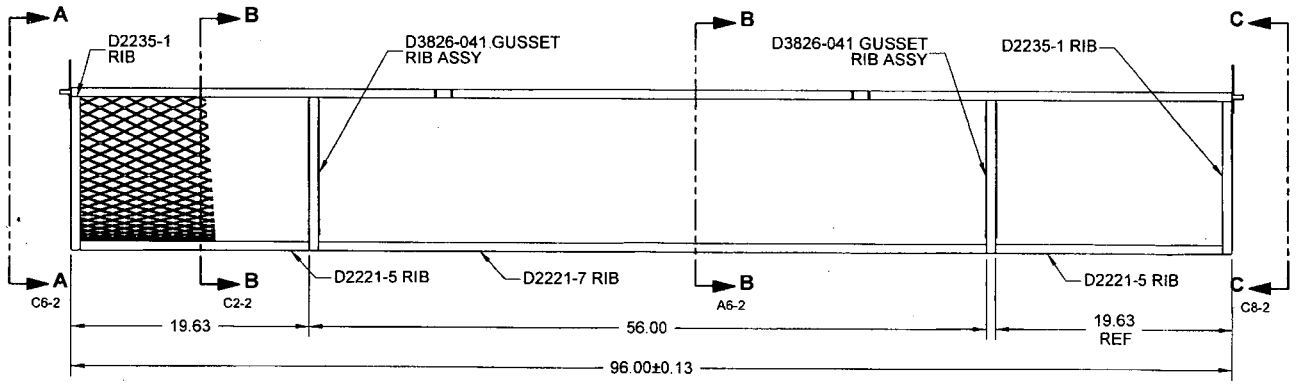
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

WO 64514





RELEASED
06/11/18 MD

D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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Dart Aerospace Ltd

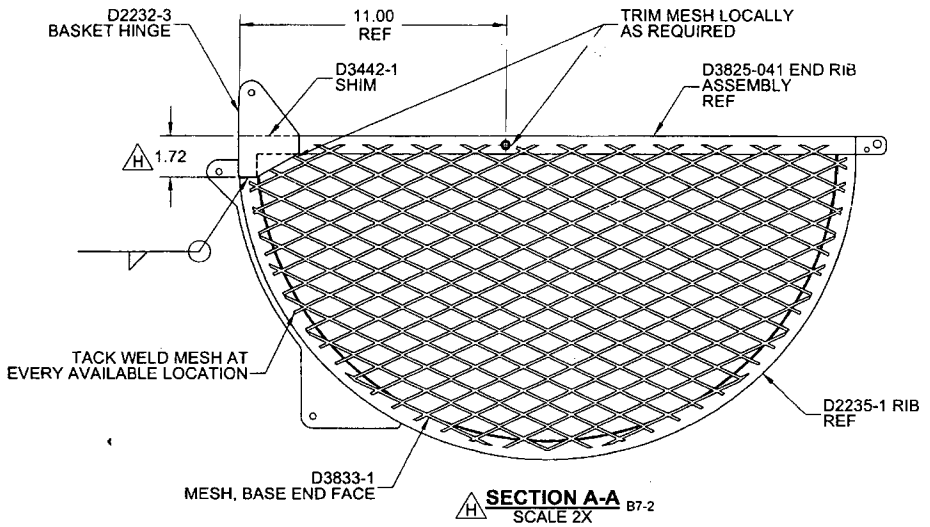
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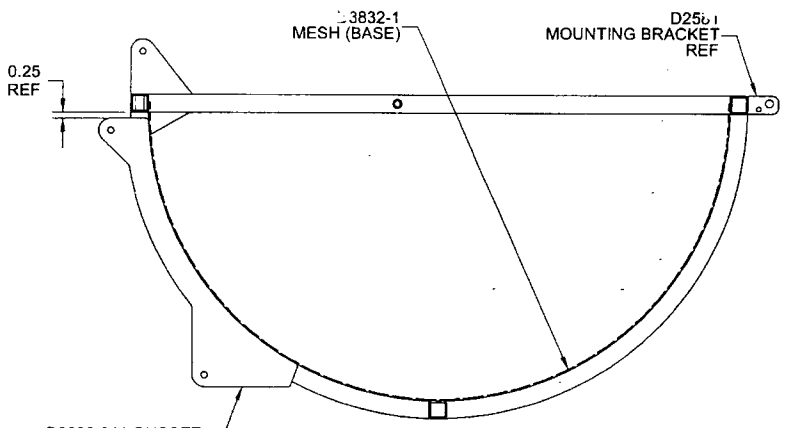
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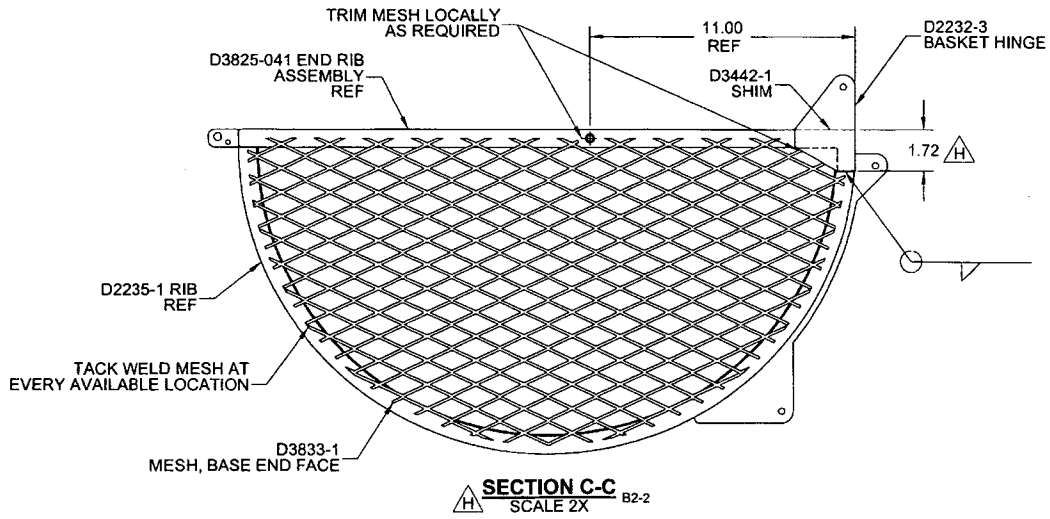
NOTE: Date & initial all entries



H **SECTION A-A** B7-2
SCALE 2X



H **SECTION B-B** B6-2 B4-2
(D3833-1 MESH NOT SHOWN FOR CLARITY)
SCALE 2X



H **SECTION C-C** B2-2
SCALE 2X

W/O 44514

RELEASED

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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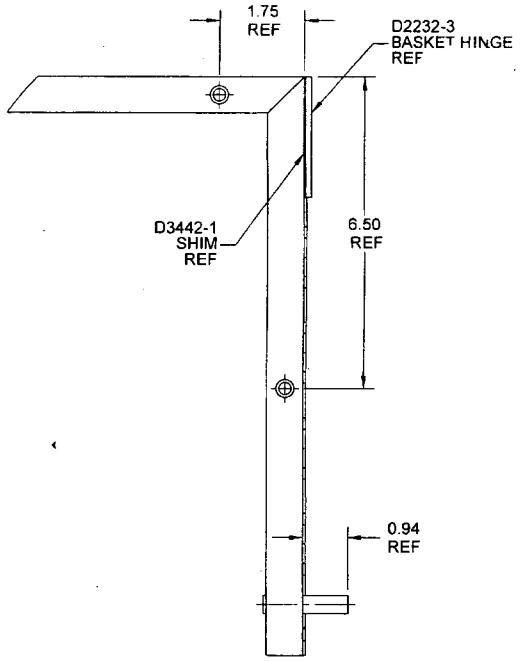
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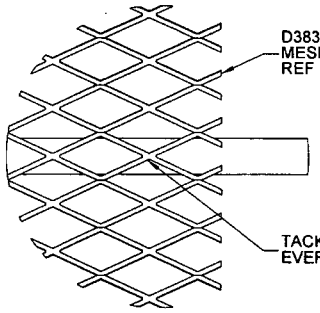
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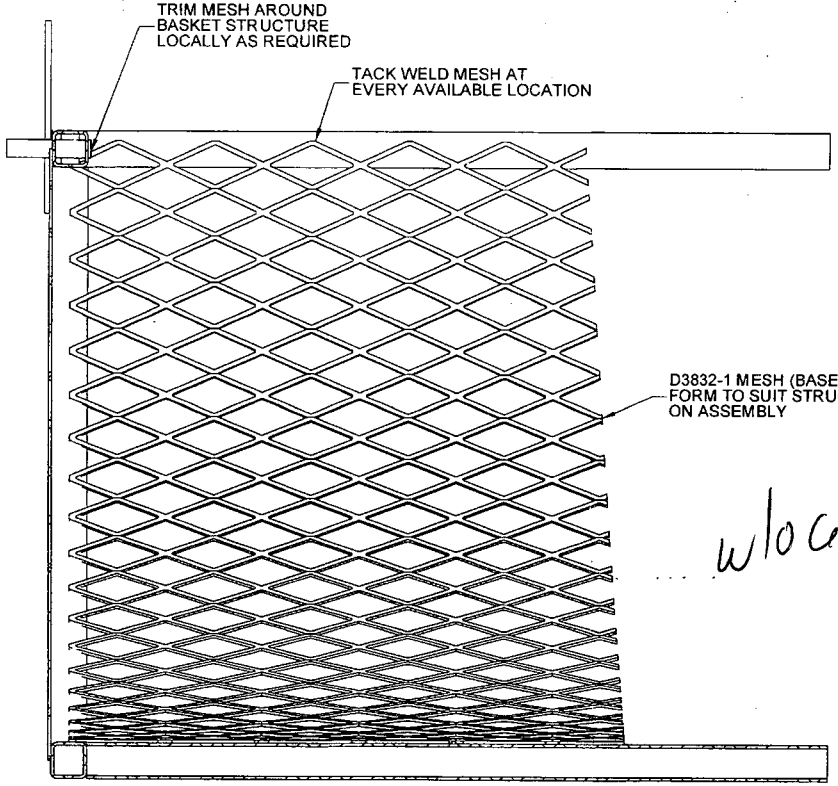
NOTE: Date & initial all entries



DETAIL D SCALE 4X D2-2



DETAIL E SCALE 4X C6-2



SECTION F-F SCALE 4X D7-2

w/o C4514

RELEASED 09/11/18 MP

DESIGN	BW	**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 4 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
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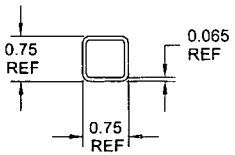
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

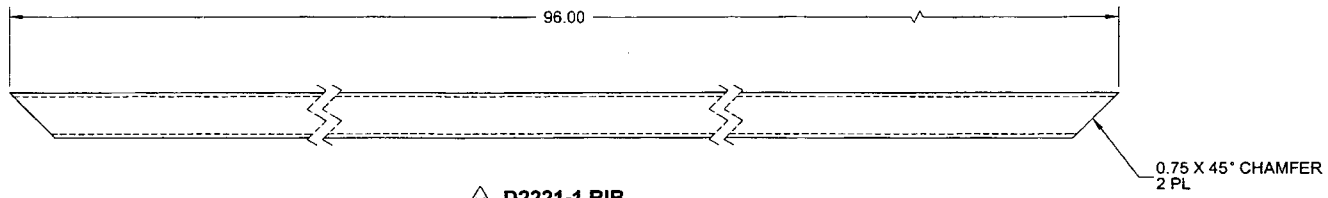
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

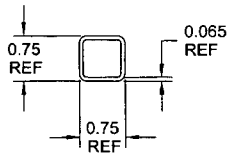
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

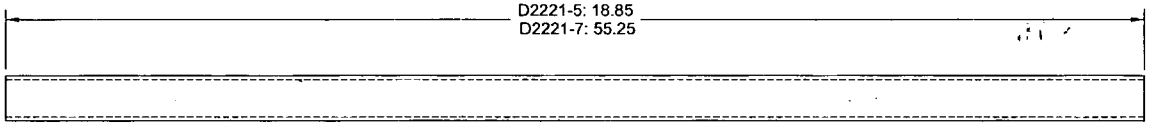
NOTE: Date & initial all entries





H **D2221-1 RIB**





H **D2221-5/-7 RIB**

w/o 44514

RELEASED
06/11/18 MD

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 5 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries